Work Order ID 70157

Monday, May 30, 2011 12:41:55 PM

Item ID: D4148-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 6/8/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-05-30 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4148 / D									
100		0.00							
Small Fab	**Memo**	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: 468	0.00							
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 70157

Monday, May 30, 2011 12:41:55 PM

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Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 6/8/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00						11/6/13	
QC	**Memo**	0.00							
Quality Control									

CL11106113

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B				**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng		**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 12:42:02 PM

Work Order ID: 70157

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Required Date:** 6/8/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C
10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02
AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	452.0000	4	8			
MS21043-4 Nut		Purchased	No			100	Each	1,640.000	1	12			

Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	372	
112314	372	

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST300	512	
117423	512	
ST301	1088	
114784	48	
115936	40	
117601	500	
117793	500	

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 12:42:02 PM

Work Order ID: 70157

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Required Date:** 6/8/2011

Start Qty: 4.00 **Required Qty:** 4.00

D2690-6	Manufactured	No		100	Each	14.0000	1	4
Lanyard Assembly								

Location	Loc Qty	Loc Code
ST020	14	
66873	14	

D3910-1	Manufactured	No		100	Each	18.0000	1	4
Crosstube Lug								

Location	Loc Qty	Loc Code
st507	18	
68263	2	
68867	16	

D4091-1	Manufactured	No		100	Each	3.0000	1	4
Mounting Lug								

Location	Loc Qty	Loc Code
ST460	3	
68868	3	

D4148-1	Manufactured	No		100	Each	5.0000	2	8
Crosstube Lug Plate, Fwd								

Location	Loc Qty	Loc Code
ST133	5	
68581	5	

D4148-3	Manufactured	No		100	Each	1.0000	1	4
Stud Receiver, Lower								

Location	Loc Qty	Loc Code
ST133	1	
68582	1	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 12:42:03 PM

Work Order ID: 70157

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Required Date:** 6/8/2011

Start Qty: 4.00 **Required Qty:** 4.00

D4148-5	Manufactured	No		100	Each	1.0000	1	4

Eyebolt Stud

Location	Loc Qty	Loc Code	
ST133	1		
67736	1		

AN3C12A	Purchased	No		100	Each	72.0000	2	8

Bolts

Location	Loc Qty	Loc Code	
ST351	72		
116924	6		
117514	36		
117794	30		

AN4C13A	Purchased	No		100	Each	93.0000	3	12

BOLT

Location	Loc Qty	Loc Code	
ST357	90		
114615	32		
116199	8		
117793	50		
ST361	3		
117688	3		

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector	
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**				

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 12:42:03 PM

Work Order ID: 70157

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/30/2011 **Required Date:** 6/8/2011

Start Qty: 4.00 **Required Qty:** 4.00

MS17984-C413 Purchased No 100 Each 27.0000 1 4

PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	27	
114340	2	
117343	5	4
117557	20	

MS20615-4M18 Purchased No 100 Each 218.0000 8 32

Rivet

Location	Loc Qty	Loc Code
ST323	218	
117411	218	

M114808 (32x)

NAS1149C0332R Purchased No 100 Each 2,182.000 4 16

Washer

Location	Loc Qty	Loc Code
ST297	2182	
116304	55	
117291	1527	16
117460	600	

NAS1149C0432R Purchased No 100 Each 6,014.000 6 24

Washer

Location	Loc Qty	Loc Code
ST297	6014	
116900	1014	24
117291	5000	

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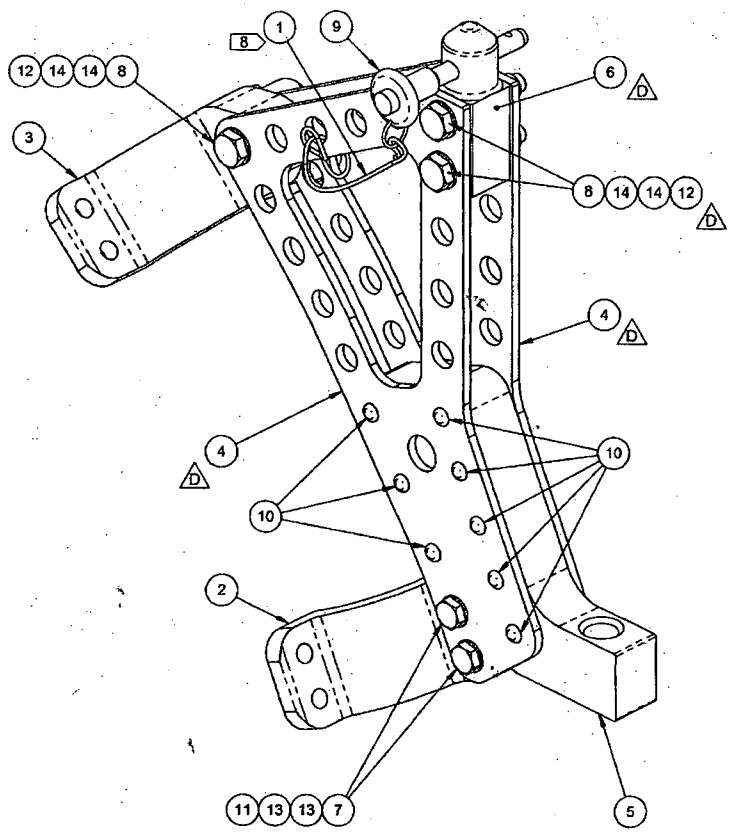
W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector	

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20157
2011-05-30

RELEASED
2011 -02- 24

D4148-041 FWD X-TUBE LUG ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
7) WEIGHT: 3.67 lbs
8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

REV.	DESCRIPTION	BY	DATE
D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1,C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18

DESIGN	MB	DART AEROSPACE LTD
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4148 REV. D
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY
DE APPR.		SCALE NTS
DATE	11.02.22	

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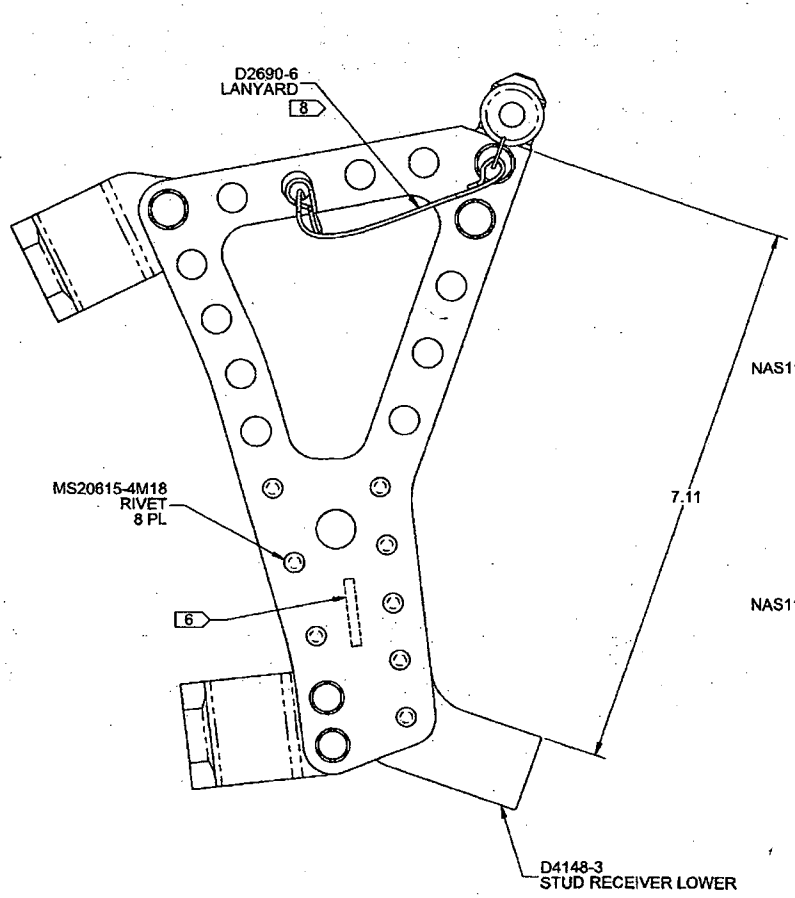
W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

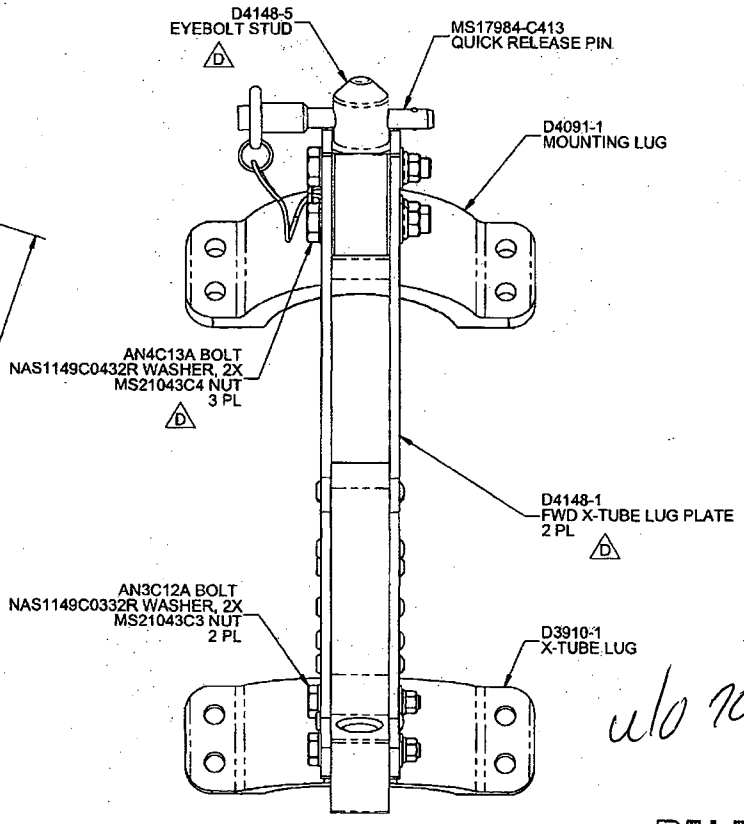
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





u/o 70157

RELEASED
2011 -02- 24
JM

D4148-041 FWD X-TUBE LUG ASSY

DESIGN	MB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4148 REV. D
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY SCALE NTS
DE APPR.		
DATE 11.02.22		

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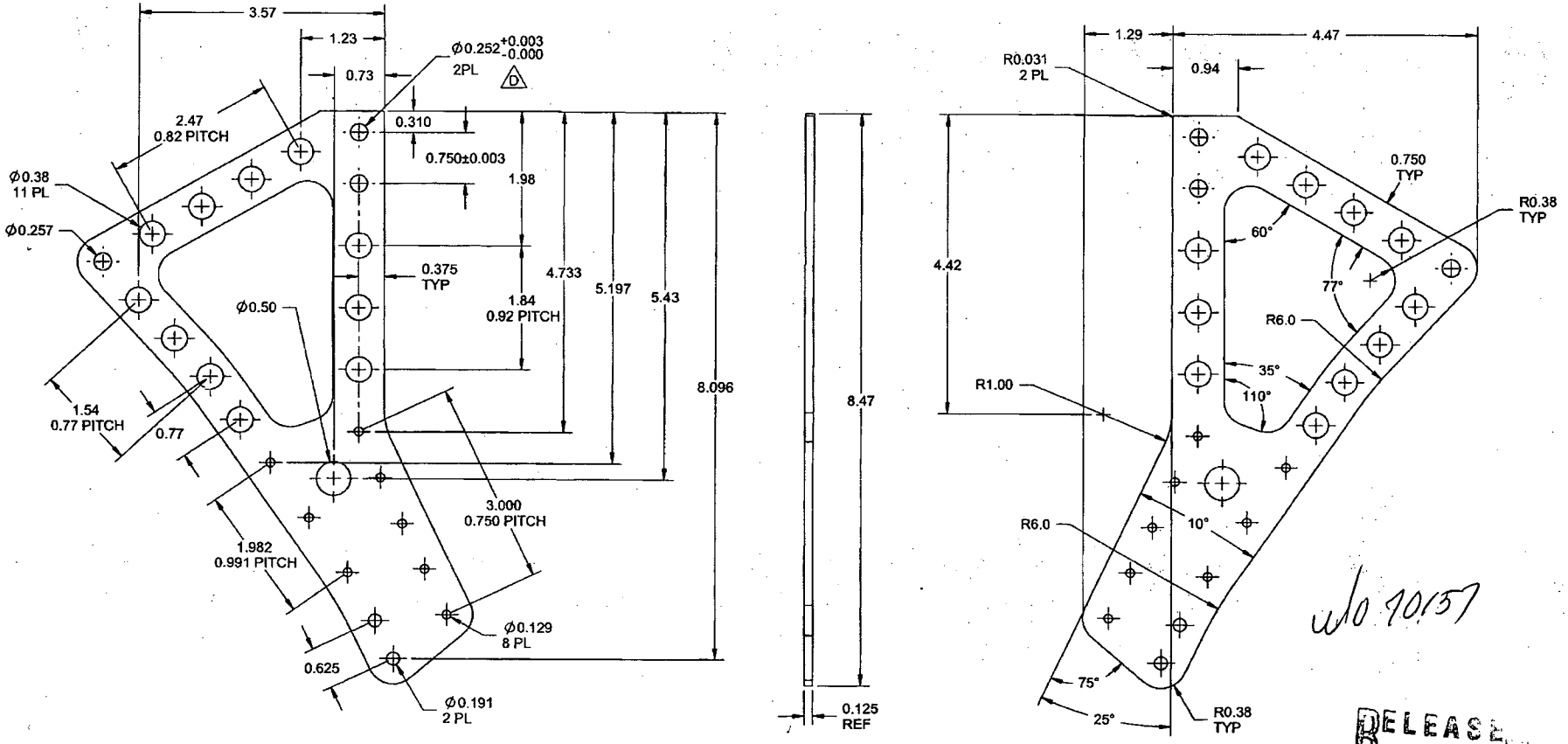
W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng		**Sign & Date**			

NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

w/o 10157

RELEASED
2011-02-24

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.52 lbs

DESIGN	MB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4148 REV. D
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY SCALE NTS
DE APPR.		
DATE	11.02.22	

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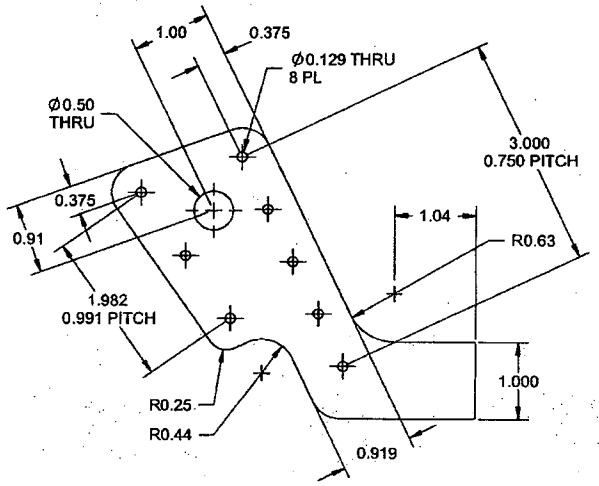
W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

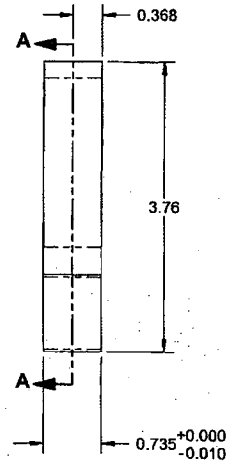
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

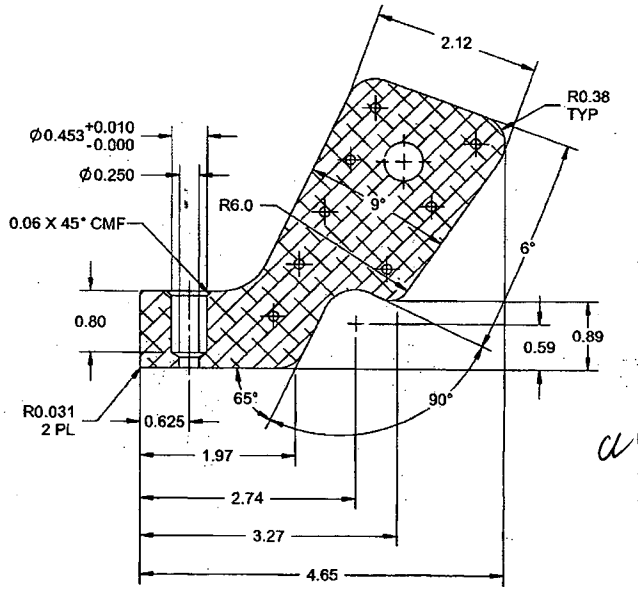
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

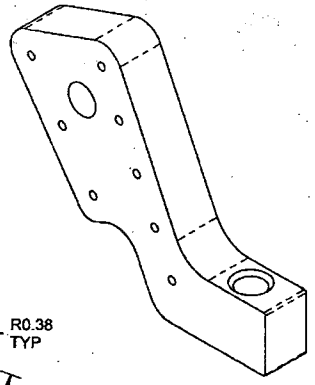




D4148-3 STUD RECEIVER LOWER



SECTION A-A



a/o 70157

RELEASED
2011 -02- 24

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.52 lbs

DESIGN	MB
DRAWN	SC
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.02.22

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4148 REV. D
SHEET 4 OF 5
TITLE FWD X-TUBE LUG ASSY
SCALE NTS

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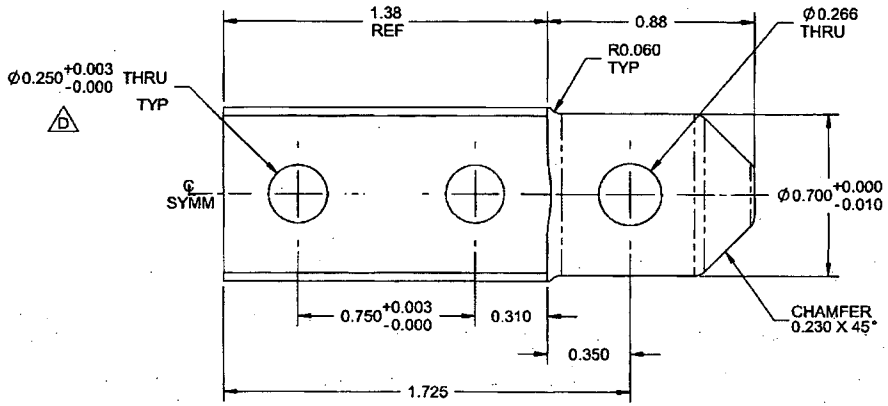
W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

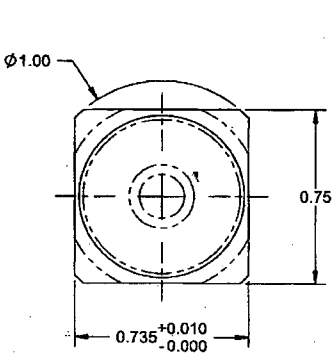
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

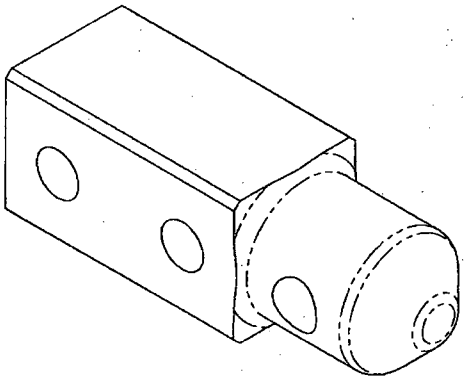
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries







D4148-5 EYEBOLT STUD

w/o 70157

RELEASED
2011 -02- 24

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4148 REV. D
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY SCALE NTS
DE APPR.		
DATE	11.02.22	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector	
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**				

NOTE: Date & initial all entries